

会    签

						船 级 社 CLASS	NK	设计阶段 DESIGN STAGE	完工图 FAINAL DRAWING					
						53500DWT DOUBLE-SKIN BULK CARRIER		船 号 SHIP NO.	DY104					
	标记 MK.	数量 QT.	通知单编号 REVISION NO.	修改人 REVISER	日期 DATE	焊接规格表 WELDING SCHEDULE								
	旧底图登记号	设 绘	DESIGNED									DY422-190-01		
		校 对	CHECKED									页 数 PAGE	重 量 WEIGHT	比 例 SCALE
底图登记号	审 核	VERIFIED			1/25									
	审 定	APPROVED			扬州大洋造船有限公司 YANGZHOU DAYANG SHIPBUILDING CO.LTD									
	日 期	DATE												

NO	Structural Member to Link	plate (mm)	plate (mm)	Welding Parameter	Type of Welding	Leg of Fillet Weld (a)	
						single	double
序号	被连接构件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
—	Cargo Hold: 货舱:						
(1)	Trans.bulkhead 横舱壁						
1	bulkhead with low stool plating 舱壁与底墩面板	15,17	16		full penetration 熔透焊		
2	bulkhead with upper stool plating 舱壁与顶墩面板	14,15	16,20	0.44	continuous 连续		9.0
3	bulkhead with hopper tank slope plate 舱壁与底边舱斜板	15,17	17,18		full penetration 熔透焊		
4	bulkhead with top side tank slope plate 舱壁与顶边舱斜板	14	13,13.5	0.44	continuous 连续		8.0
5	bulkhead with top side tank slope plate 舱壁与顶边舱斜板	14	14	0.44	continuous 连续		9.0
6	bulkhead with top side tank slope plate 舱壁与顶边舱斜板	14	12,12.5	0.44	continuous 连续		8.0
7	bulkhead with side longi.bulkhead 舱壁与纵舱壁	14	13	0.44	continuous 连续		8.0
8	bulkhead with side longi.bulkhead 舱壁与纵舱壁	14	14,15	0.44	continuous 连续		9.0
9	bulkhead with side longi.bulkhead 舱壁与纵舱壁	15,17	15	0.44	continuous 连续		9.5
10	low stool self plating with low stool 底墩面板与底墩	16	15		full penetration 熔透焊		
11	upper stool plating with upper stool 顶墩面板与顶墩	16,20	11	0.44	continuous 连续		7.0
12	low stool with hopper tank slope plate 底墩与底边舱斜板	15	17,18,21		full penetration 熔透焊		
13	low stool with hopper tank slope plate 底墩与底边舱斜板	17	21		full penetration 熔透焊		
14	upper stool with top side tank slope plate 顶墩与顶边舱斜板	11	12.5,14 17.5	0.44	continuous 连续		7.0
15	low stool with inner bottom 底墩与内底板	15,17	22.5		full penetration 熔透焊		
16	upper stool with upper deck 顶墩与上甲板	11	11,20	0.44	continuous 连续		7.0
17	upper stool with seat of crane post 顶墩与起重柱机座	11			penetration 深熔焊		
18	girder on upper deck with seat of crane post 上甲板纵桁与起重柱机座	18			penetration 深熔焊		
19	clapboard with clapboard in seat of crane post 起重柱机座内格板与隔板	18	18		penetration 深熔焊		
20	upper stool plating with seat of crane post 顶墩面板与起重机基座	20			penetration 深熔焊		

NO	Structural Member to Link	plate (mm)	plate (mm)	Welding Parameter	Type of Welding	Leg of Fillet Weld (a)	
						single	double
序号	被 连 接 构 件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
21	hopper tank trans.bulkhead plate with slope plate 底边舱横舱壁板与斜板	14	17,18 21		full penetration 熔透焊		
22	hopper tank trans.bulkhead plate with platform 底边舱横舱壁板与平台板	14	12	0.44	continuous 连续		7.5
23	hopper tank trans.bulkhead plate with side girder 底边舱横舱壁板与旁桁材	14	11.5	0.44	continuous 连续		7.5
24	hopper tank trans.bulkhead plate with shell 底边舱横舱壁板与外板	14	14,16	0.44	continuous 连续		9.0
25	top side tank trans.bulkhead plate with upper deck 顶边舱横舱壁板与上甲板	12	15,21	0.44	continuous 连续		7.5
26	top side tank trans.bulkhead plate with slope plate 顶边舱横舱壁板与斜板	12	12~17.5	0.44	continuous 连续		7.5
27	top side tank trans.bulkhead plate with platform 顶边舱横舱壁板与平台板	12	12	0.44	continuous 连续		7.5
28	top side tank trans.bulkhead plate with shell 顶边舱横舱壁板与外板	12	13,14,15, 17	0.44	continuous 连续		7.5
29	hopper tank clapboard with slope plate 底边舱隔板与斜板	11	17,18 21	0.13	continuous 连续		6.0
30	hopper tank clapboard with platform 底边舱隔板与平台板	11	12	0.13	continuous 连续		6.0
31	hopper tank clapboard with side girder 底边舱隔板与旁桁材	11	11.5	0.13	continuous 连续		6.0
32	hopper tank clapboard with shell 底边舱隔板与外板	11	14,16	0.13	continuous 连续		6.0
33	top side tank clapboard with upper deck 顶边舱隔板与上甲板	10	21	0.13	continuous 连续		5.0
34	top side tank clapboard with slope plate 顶边舱隔板与斜板	10	12~17.5	0.13	continuous 连续		5.0
35	top side tank clapboard with platform 顶边舱隔板与平台板	10	12	0.13	continuous 连续		5.0
36	top side tank clapboard with shell 顶边舱隔板与外板	10	13~17	0.13	continuous 连续		5.0
37	side clapboard with side longi.bulkhead 舷侧隔板与纵舱壁	10	11~15	0.13	continuous 连续		6.0
38	side clapboard with platform 舷侧隔板与平台板	10	9,12	0.13	continuous 连续		5.0
39	side clapboard with shell 舷侧隔板与外板	10	14~15	0.13	continuous 连续		5.0
40	hopper tank trans.bulkhead plate with stiffener 底边舱横舱壁板与加强筋	14	12	0.13	continuous 连续		6.0
41	hopper tank clapboard with stiffener 底边舱隔板与加强筋	11	11	0.13	continuous 连续		5.0

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序号	被连接构件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
42	top side tank trans.bulkhead plate with stiffener 顶边舱横舱壁板与加强筋	12	9,10	0.13	continuous 连续		5.0
43	top side tank clapboard with stiffener 顶边舱隔板与加强筋	10	12	0.13	continuous 连续		5.0
44	side bulkhead with stiffener 边舱壁与加强筋	12,13	12	0.34	continuous		7.0
45	side clapboard with stiffener 舷侧隔板与加强筋	10,11	12	0.13	continuous 连续		5.0
46	brackets 肘板		12		continuous 连续		6.0
(2)	upper deck Construction 上甲板结构						
1	beams with cross deck 横梁与甲板条	12	11,20	0.10	continuous 连续		5.0
2	girder with cross deck 纵桁与甲板条	10	11,20	0.44	continuous 连续		6.0
3	longitudinals with upper deck 纵骨与上甲板	20	14	0.10	continuous 连续		7.0
4	longitudinals with upper deck 纵骨与上甲板	20	16,18	0.10	continuous 连续		8.0
5	longitudinals with upper deck 纵骨与上甲板	20	21	0.10	continuous 连续		9.0
6	longitudinals with upper deck 纵骨与上甲板	18	18,21	0.10	continuous 连续		8.0
7	longitudinals with upper deck 纵骨与上甲板	18	15	0.10	continuous 连续		7.0
8	longitudinals with upper deck 纵骨与上甲板	11	12,15	0.10	continuous 连续		6.0
9	brackets 肘板		12		continuous 连续		6.0
10	brackets 肘板		10		continuous 连续		5.0
11	brackets 肘板		9		continuous 连续		5.0

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序号	被 连 接 构 件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
(3)	<b>hatch coamings Construction</b> <b>舱口围板结构</b>						
1	hatch coamings with upper deck 舱口围板与上甲板	14	14,16,18 15,21	0.34	continuous 连续		7.0
2	hatch coamings with upper deck 舱口围板与上甲板	14	11	0.34	continuous 连续		6.0
3	hatch coamings with upper deck(in the corner) 舱口围板与上甲板（角隅处）	14	14,15,18 21	0.44	continuous 连续		9.0
4	hatch coamings with upper deck(in the corner) 舱口围板与上甲板（角隅处）	14	12	0.44	continuous 连续		8.5
5	hatch coamings with top plate 舱口围板与面板	14	20	0.27	continuous 连续		8.0
6	longi. stiffener with hatch coaming 纵向加强筋与舱口围板	10	14	0.13	continuous 连续		5.0
7	top plate with Longi stiffener 面板与纵向加强筋	20	20	0.44	continuous 连续		13.0
8	brackets with hatch coaming 肘板与舱口围板	12	14		continuous 连续		6.0
9	brackets with hatch coaming 肘板与舱口围板	10	14		continuous 连续		5.0
10	brackets with upper deck 肘板与上甲板	10	12~18		continuous 连续		5.0
11	brackets with Face plate 肘板与面板	10 12	12	0.27	continuous 连续		5.0
(4)	<b>decks And frame Construction (In Cargo Holds)</b> <b>货舱甲板与舷侧结构</b>						
1	upper deck with shell plate 上甲板与外板	14	14		full penetration 熔透焊		
2	upper deck with shell plate 上甲板与外板	16	14.5		full penetration 熔透焊		
3	upper deck with shell plate 上甲板与外板	16, 18	15,16		full penetration 熔透焊		
4	upper deck with shell plate 上甲板与外板	21	17		full penetration 熔透焊		
5	upper deck with shell plate 上甲板与外板	15	14,14.5		full penetration 熔透焊		
6	upper deck with shell plate 上甲板与外板	12	13		full penetration 熔透焊		
8	platform with shell plate 平台板与外板	12	14,14.5, 15,16	0.21	continuous 连续		6.0

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						单面	双面
9	platform with shell plate 平台板与外板	9	14,15	0.10	continuous 连续		5.0
10	platform with longi.bulkhead 平台板与纵壁	12	12,13,15,	0.21	continuous 连续		6.0
11	platform with longi.bulkhead 平台板与纵壁	9	11,13, 14	0.21	continuous 连续		5.0
12	top side tank slope plate with hatch Stringer 顶边舱斜板与舱口纵桁	17.5	16	0.44	continuous 连续		10.0
13	top side tank slope plate with longi.bulkhead 顶边舱斜板与纵壁	12	12,13		full penetration 熔透焊		
14	top side tank slope plate with longi.bulkhead 顶边舱斜板与纵壁	13.5	12		full penetration 熔透焊		
15	top side tank slope plate with longi.bulkhead 顶边舱斜板与纵壁	13.5	13		full penetration 熔透焊		
16	hopper tank slope plate with inner bottom 底边舱斜板与内底板	21	22.5		full penetration 熔透焊		
17	longitudinals with shell plate 纵骨与外板	10	14,14.5, 15,17	0.13	continuous 连续		5.0
18	longitudinals with shell plate 纵骨与外板	12	16,17	0.13	continuous 连续		6.0
19	longitudinals with shell plate 纵骨与外板	12	14,14.5 13	0.13	continuous 连续		5.0
20	longitudinals with shell plate 纵骨与外板	13	13,14,15 14.5	0.13	continuous 连续		7.0
21	longitudinals with hopper tank slope plate 纵骨与底边舱斜板	11	17,21	0.13	continuous 连续		6.0
22	longitudinals with hopper tank slope plate 纵骨与底边舱斜板	12	17,18,21	0.13	continuous 连续		7.0
23	longitudinals with longi.bulkhead 纵骨与纵壁	9	11,12,13	0.13	continuous 连续		5.0
24	longitudinals with longi.bulkhead 纵骨与纵壁	10	11,13 15	0.13	continuous 连续		5.0
25	longitudinals with longi.bulkhead 纵骨与纵壁	11	13,14 15	0.13	continuous 连续		6.0
26	longitudinals with longi.bulkhead 纵骨与纵壁	12	14,15	0.13	continuous 连续		7.0
27	longitudinals with top side tank slope plate 纵骨与顶边舱斜板	11	14,17.5 12.5	0.13	continuous 连续		6.0
28	longitudinals with top side tank slope plate 纵骨与顶边舱斜板	12	12,12.5, 13,14	0.13	continuous 连续		7.0
29	longitudinals with top side tank slope plate 纵骨与顶边舱斜板	13	12,13 13.5	0.13	continuous 连续		7.0
30	inner bottom with Trans. Bulkhead(FR217) 内底板与横舱壁	22.5	18.5		full penetration 熔透焊		

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						单面	双面
31	Trans bulkhead with shell plate(FR217)	18.5,18	15	0.44	continuous		9.5
	横舱壁与外板				连续		
32	Trans bulkhead with shell plate(FR217)	17,16,15	15	0.44	continuous		9.5
	横舱壁与外板				连续		
33	Trans bulkhead with shell plate(FR217)	14,15	14	0.44	continuous		9.0
	横舱壁与外板				连续		
34	Trans bulkhead with shell plate(FR217)	14	16	0.44	continuous		9.0
	横舱壁与外板				连续		
35	Trans bulkhead with shell plate(FR217)	12.5	16	0.44	continuous		8.0
	横舱壁与外板				连续		
36	Trans bulkhead with shell plate(FR217)	11	13,16	0.44	continuous		7.0
	横舱壁与外板				连续		
37	Trans bulkhead with shell plate(FR217)	10	13	0.44	continuous		6.0
	横舱壁与外板				连续		
38	Trans bulkhead with slope plate(FR217)	18.5	21	0.44	continuous		11.5
	横舱壁与斜板				连续		
39	Trans bulkhead with slope plate(FR217)	18	21	0.44	continuous		11.0
	横舱壁与斜板				连续		
40	Trans bulkhead with slope plate(FR217)	17,18	17	0.44	continuous		10.5
	横舱壁与斜板				连续		
41	Trans bulkhead with longi.bulkhead(FR217)	16,17	15	0.44	continuous		9.5
	横舱壁与纵壁				连续		
42	Trans bulkhead with longi.bulkhead(FR217)	14,15,16	13	0.44	continuous		8.0
	横舱壁与纵壁				连续		
43	Trans bulkhead with longi.bulkhead(FR217)	12.5	13	0.44	continuous		8.0
	横舱壁与纵壁				连续		
44	Trans bulkhead with longi.bulkhead(FR217)	11	13	0.44	continuous		7.0
	横舱壁与纵壁				连续		
45	Trans bulkhead with longi.bulkhead(FR217)	10	12,13	0.44	continuous		6.0
	横舱壁与纵壁				连续		
46	brackets		10		continuous		5.0
	肘板				连续		
47	brackets		12		continuous		6.0
	肘板				连续		
(5)	Double bottom In Cargo Hold						
	货舱双层底						
1	duct keel with shell plate	13~19	18,19.5		penetration		
	箱型桁材与外板		20.5,17.5		深熔焊		
2	duct keel with inner bottom	13~19	22.5		penetration		
	箱型桁材与内底板				深熔焊		

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						单面	双面
3	duct web with inner bottom plate 管弄横向骨材与内底板	16	22.5	0.44	continuous 连续		10.0
4	duct longitudinals with inner bottom plate 管弄纵骨与内底板	9	22.5	0.44	continuous 连续		6.0
5	duct web with shell plate 管弄横向骨材与外板	16	18,19.5 17.5,20.5	0.44	continuous 连续		10.0
6	duct longitudinals with shell plate 管弄纵骨与外板	10	18,19.5 17.5,20.5	0.44	continuous 连续		6.5
7	center girder with Flatkeel 中桁材与平板龙骨	12	17.5,17	0.44	continuous 连续		8.0
8	center girder with Flatkeel 中桁材与平板龙骨	13.5	17.5,20.5	0.44	continuous 连续		8.5
9	center girder with inner bottom plate 中桁材与内底板	12	22.5	0.44	continuous 连续		8.0
10	center girder with inner bottom plate 中桁材与内底板	13.5	22.5	0.44	continuous 连续		8.5
11	side girder with inner bottom plate 旁桁材与内底板	11.5	22.5	0.44	continuous 连续		7.0
12	side girder with inner bottom plate 旁桁材与内底板	12,13	22.5	0.44	continuous 连续		8.0
13	side girder with inner bottom plate 旁桁材与内底板	14,14.5	22.5	0.44	continuous 连续		9.0
14	side girder with inner bottom plate 旁桁材与内底板	15	22.5	0.44	continuous 连续		9.5
15	side girder with inner bottom plate 旁桁材与内底板	16	22.5	0.44	continuous 连续		10.0
16	side girder with inner bottom plate 旁桁材与内底板	17	22.5	0.44	continuous 连续		10.5
17	side girder with inner bottom plate 旁桁材与内底板	18	22.5	0.44	continuous 连续		11.0
18	side girder with inner bottom plate 旁桁材与内底板	19	22.5	0.44	continuous 连续		12.0
19	side girder with inner bottom plate 旁桁材与内底板	21	22.5	0.44	continuous 连续		13.0
20	side girder with shell plate 旁桁材与外板	11.5	14~23.5	0.44	continuous 连续		7.0
21	side girder with shell plate 旁桁材与外板	12,13	14~23.5	0.44	continuous 连续		8.0
22	side girder with shell plate 旁桁材与外板	14,14.5	>14	0.44	continuous 连续		9.0
23	side girder with shell plate 旁桁材与外板	15	>15	0.44	continuous 连续		9.5



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						single	double
序号	被连接构件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
24	side girder with shell plate 旁桁材与外板	16	>16	0.44	continuous 连续		10.0
25	side girder with shell plate 旁桁材与外板	17	>17	0.44	continuous 连续		10.5
26	side girder with shell plate 旁桁材与外板	18	>18	0.44	continuous 连续		11.0
27	side girder with shell plate 旁桁材与外板	19	>19	0.44	continuous 连续		12.0
28	side girder with shell plate 旁桁材与外板	21	>21	0.44	continuous 连续		13.0
29	side girder with shell plate 旁桁材与外板	19	16	0.44	continuous 连续		10.0
30	side girder with shell plate 旁桁材与外板	21	19.5	0.44	continuous 连续		12.0
31	floor(W.T) with inner bottom plate 水密肋板与内底板	14	22.5		full penetration 熔透焊		
32	floor(W.T) with shell plate 水密肋板与外板	14	14~21	0.44	continuous 连续		9.0
33	floor(W.T) with duct keel 水密肋板与箱型桁材	14	15,18,19	0.44	continuous 连续		8.0
34	floor(W.T) with center girder 水密肋板与中桁材	14	13.5	0.44	continuous 连续		8.5
35	floor(N.W.T) with center girder 非水密肋板与中桁材	12	12,13.5	0.13	continuous 连续		7.0
36	floor(W.T) with side girder 水密肋板与旁桁材	14	11.5	0.44	continuous 连续		7.0
37	floor(W.T) with side girder 水密肋板与旁桁材	14	12	0.44	continuous 连续		7.5
38	floor(W.T) with side girder 水密肋板与旁桁材	14	13	0.44	continuous 连续		8.0
39	floor(W.T) with side girder 水密肋板与旁桁材	14	14~21	0.44	continuous 连续		9.0
40	floor ( N.W.T) with inner bottom 非水密肋板与内底板	12~20	22.5	0.13	continuous 连续		6.0
41	floor ( N.W.T) with shell plate 非水密肋板与外板	12~20	14~23.5	0.13	continuous 连续		6.0
42	floor(N.W.T) with duct keel 非水密肋板与箱型桁材	12~20	13~19	0.13	continuous 连续		6.0
43	floor(N.W.T) with side girder 非水密肋板与旁桁材	12~20	11.5~21	0.13	continuous 连续		6.0
44	bottom longi. with shell plate 船底纵骨与外板	11	14~23.5	0.13	continuous 连续		6.0

NO	Structural Member to Link	plate (mm)	plate (mm)	Welding Parameter	Type of Welding	Leg of Fillet Weld (a)	
						single	double
序号	被连接构件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
45	bottom longi. with shell plate 船底纵骨与外板	12	14~23.5	0.13	continuous 连续		7.0
46	inner bottom longi. with inner bottom plate 内底纵骨与内底板	13	22.5	0.44	continuous 连续		8.0
47	center girder with longi. Stiffener 中桁材与纵骨	12,13.5	10	0.13	continuous 连续		5.0
48	stiffener with side girder ( N.W.T) 加强筋与非水密旁桁材	11.5	11.5~21	0.13	continuous 连续		6.0
49	stiffener with side girder ( W.T) 加强筋与水密旁桁材	10	12	0.13	continuous 连续		5.0
50	stiffener with floor ( N.W.T) 加强筋与非水密肋板	12	12~21	0.13	continuous 连续		6.0
51	stiffener with floor ( W.T) 加强筋与水密肋板	12	14	0.13	continuous 连续		6.0
52	bilge well plate with floor ( W.T) 污水井板与水密肋板	17	14	0.34	continuous 连续		8.0
53	bilge well plate with side girder 污水井板与旁桁材	17	12	0.34	continuous 连续		7.0
54	bilge well plate with inner bottom 污水井板与内底板	17	22.5	0.34	continuous 连续		8.0
55	doubling of bilge keel with shell 舦龙骨复板与外板	14	14	0.13	continuous 连续		7.0
56	doubling with web of bilge keel 舦龙骨复板与腹板	14	14	0.13	continuous 连续		4.5
57	web with web of bilge keel 舦龙骨腹板与腹板	11	14	0.13	continuous 连续		5.5
58	brackets 肘板	10	12		continuous 连续		6.0
59	brackets 肘板	12	14		continuous 连续		7.0
二	M/E Room: 机舱 :						
(1)	Double bottom In M/E Room: 机舱双层底 :						
1	inner bottom plate with shell plate 内底板与外板	20,16	15	0.44	continuous 连续		9.5
2	inner bottom plate with side girder 内底板与旁桁材	16	16,20	0.44	continuous 连续		10.0

NO	Structural Member to Link	plate (mm)	plate (mm)	Welding Parameter	Type of Welding	Leg of Fillet Weld (a)	
						single	double
序号	被 连 接 构 件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
3	inner bottom plate with side girder 内底板与旁桁材	20	20	0.44	continuous 连续		13.0
4	inner bottom plate with side girder 内底板与旁桁材	16	14	0.44	continuous 连续		9.0
5	shell plate with center girder 外板与中桁材	18,20	16	0.44	continuous 连续		10.0
6	shell plate with center girder 外板与中桁材	20	20	0.44	continuous 连续		13.0
7	center girder with inner bottom plate 中桁材与内底板	20	20	0.44	continuous 连续		13.0
8	center girder with inner bottom plate 中桁材与内底板	16	16	0.44	continuous 连续		10.0
9	M/E seating girder with shell plate 机座纵桁材与外板	28	20		penetration 深熔焊		
10	M/E seating girder with shell plate 机座纵桁材与外板	28	15		penetration 深熔焊		
11	M/E seating girder with inner bottom plate 机座纵桁材与内底板	28	20		penetration 深熔焊		
12	M/E seating girder with Top plate 机座纵桁材与顶板	28	50		penetration 深熔焊		
13	girder with Top plate (in way of Found. Bol.) 半高纵桁材与顶板 (机座螺栓范围内)	36	50		penetration 深熔焊		
14	M/E seating girder with floor 机座纵桁材与肋板	28	15	0.27	continuous 连续		9.5
15	M/E seating And inner bottom with brackets 机座纵桁和内底板与肘板	28,20	20	0.21	continuous 连续		13.0
16	M/E seating clapboard with M/E seating 机座横隔板与机座纵桁	20	28	0.27	continuous 连续		13.0
17	M/E seating clapboard with M/E seating 机座横隔板与机座纵桁	22	28	0.27	continuous 连续		14.0
18	M/E seating clapboard with inner bottom plate 机座横隔板与内底板	20	20	0.27	continuous 连续		13.0
19	M/E seating clapboard with Top plate 机座横隔板与顶板	22	50	0.27	continuous 连续		14.0
20	M/E seating clapboard with shell plate 机座横隔板与外板	20	20	0.27	continuous 连续		12.0
21	M/E seating clapboard with shell plate 机座横隔板与外板	20	18	0.27	continuous 连续		11.0
22	M/E seating clapboard with shell plate 机座横隔板与外板	22	20	0.27	continuous 连续		12.0
23	M/E seating clapboard with shell plate 机座横隔板与外板	22	18	0.27	continuous 连续		11.0
24	M/E seating clapboard with shell plate 机座横隔板与外板	22	15	0.27	continuous 连续		9.0

NO	Structural Member to Link	plate (mm)	plate (mm)	Welding Parameter	Type of Welding	Leg of Fillet Weld (a)	
						single	double
序号	被连接构件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
25	boundaries of M/E seating tank bottom plate 机座循环油舱底板周界	20	20,28	0.27	continuous 连续		12.0
26	inner bottom plate with floor 内底板与肋板	16	14	0.27	continuous 连续		8.5
27	inner bottom plate with floor 内底板与肋板	16	16,17,20	0.27	continuous 连续		9.5
28	inner bottom plate with floor 内底板与肋板	16,20 50	15	0.27	continuous 连续		9.0
29	inner bottom plate with floor 内底板与肋板	16	13	0.27	continuous 连续		8.0
30	shell plate with floor 外板与肋板	15,18 20	14	0.27	continuous 连续		8.5
31	shell plate with floor 外板与肋板	15,18 20	15	0.27	continuous 连续		9.0
32	shell plate with floor 外板与肋板	20	13	0.27	continuous 连续		8.0
33	shell plate with floor 外板与肋板	20	20	0.27	continuous 连续		12.0
34	shell plate with floor 外板与肋板	18	20	0.27	continuous 连续		11.0
35	floor with side girder 肋板与旁桁材	15	16	0.27	continuous 连续		9.0
36	floor with side girder 肋板与旁桁材	13	16	0.27	continuous 连续		8.0
37	floor with side girder 肋板与旁桁材	14	16,20	0.27	continuous 连续		8.5
38	stiffener with floor ( N.W.T) 加强筋与非水密肋板	15	15	0.10	continuous 连续		7.5
39	stiffener with floor ( N.W.T) 加强筋与非水密肋板	14	14	0.10	continuous 连续		7.0
40	stiffener with floor ( W.T) 加强筋与水密肋板	11	15	0.10	continuous 连续		6.0
41	inner bottom with pillars 内底板与支柱	16	20	0.44	continuous 连续		10.0
42	brackets with floor 肘板与肋板	16	15		continuous 连续		8.0
43	brackets with floor 肘板与肋板	14	14		continuous 连续		8.0
(2)	side & deck of M/E Room: 机舱舷侧及甲板：						

NO	Structural Member to Link	plate (mm)	plate (mm)	Welding Parameter	Type of Welding	Leg of Fillet Weld (a)	
						single	double
序号	被 连 接 构 件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
1	upper deck with Sheerstake 上甲板与舷顶列板	10	14		penetration 深熔焊		
2	upper deck with Sheerstake 上甲板与舷顶列板	12	14		penetration 深熔焊		
3	upper deck with Sheerstake 上甲板与舷顶列板	14	14		penetration 深熔焊		
4	Coffer bottom plate with shell plate 隔离空舱底板与外板	8	14	0.34	continuous 连续		5.0
5	Coffer bottom plate with longi.bulkhead 隔离空舱底板与纵壁板	8	9	0.34	continuous 连续		5.0
6	upper platform with shell plate 上平台板与外板	9	14.5	0.34	continuous 连续		5.0
7	upper platform with shell plate 上平台板与外板	10	14.5,15	0.34	continuous 连续		5.0
8	longi.bulkhead with upper deck 纵壁与上甲板	7	10,12	0.34	continuous 连续		5.0
9	longi.bulkhead with upper deck 纵壁与上甲板	8	9,10	0.13	continuous 连续		5.0
12	oil tank longi.bulkhead with upper platform 油舱纵壁与上平台板	9	10,11	0.13	continuous 连续		5.0
13	oil tank longi.bulkhead with bottom platform 油舱纵壁与底板	9	8.5	0.34	continuous 连续		5.0
14	upper platform with bulkhead 机舱上平台与舱壁	9	7	0.13	continuous 连续		5.0
15	upper platform with bulkhead 机舱上平台与舱壁	9	9	0.34	continuous 连续		5.0
16	upper platform with bulkhead 机舱上平台与围壁	12	9	0.44	continuous 连续		5.0
17	oil tank Top plate with bulkhead 油舱顶板与舱壁	8	8	0.34	continuous 连续		5.0
18	upper platform with pillars 机舱上平台与支柱	9	16	0.44	continuous 连续		6.0
19	lower platform with shell plate 机舱下平台与外板	9	14.5	0.34	continuous 连续		5.0
20	lower platform with shell plate 机舱下平台与外板	10	14.5,15	0.34	continuous 连续		5.5
21	lower platform with shell plate 机舱下平台与外板	12	14.5,15	0.34	continuous 连续		7.0
22	lower platform with bulkhead 机舱下平台与舱壁	9	12	0.44	continuous 连续		5.0
23	lower platform with bulkhead 机舱下平台与舱壁	12	10	0.44	continuous 连续		6.0
24	lower platform with bulkhead 机舱下平台与围壁	9	8,9 10,11	0.13	continuous 连续		5.0

NO	Structural Member to Link	plate (mm)	plate (mm)	Welding Parameter	Type of Welding	Leg of Fillet Weld (a)	
						single	double
序号	被 连 接 构 件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
25	lower platform with bulkhead 机舱下平台与围壁	12	9	0.13	continuous 连续		5.0
26	oil tank top plate with shell plate 油舱顶板与外板	8	14.5	0.44	continuous 连续		5.0
27	oil tank top plate with bulkhead 油舱顶板与舱壁	8	9	0.34	continuous 连续		5.0
28	oil tank bottom plate with bulkhead 油舱底板与舱壁	9	10	0.34	continuous 连续		6.0
29	lower platform with pillars 机舱下平台与支柱	9	20	0.44	continuous 连续		6.0
30	bulkhead with shell plate 舱壁与外板(FR12)	30,20	20	0.44	continuous 连续		13.0
31	bulkhead with shell plate 舱壁与外板(FR12)	20,16	14	0.44	continuous 连续		9.0
32	bulkhead with shell plate 舱壁与外板(FR12)	12	14	0.44	continuous 连续		8.0
33	bulkhead with shell plate 舱壁与外板(FR35)	13	15	0.44	continuous 连续		8.0
34	bulkhead with shell plate 舱壁与外板(FR35)	12	15	0.44	continuous 连续		8.0
35	bulkhead with shell plate 舱壁与外板(FR35)	11	15	0.44	continuous 连续		7.0
36	bulkhead with shell plate 舱壁与外板	10	14, 15	0.44	continuous 连续		6.0
37	bulkhead with shell plate 舱壁与外板	9	14	0.44	continuous 连续		5.0
38	bulkhead with shell plate 舱壁与外板	8	14	0.44	continuous 连续		5.0
39	bulkhead with upper deck 舱壁与上甲板	8	11	0.44	continuous 连续		5.0
40	bulkhead with upper deck 舱壁与上甲板	10	11	0.44	continuous 连续		6.0
41	bulkhead with upper deck 舱壁与上甲板	12	14	0.44	continuous 连续		8.0
42	bulkhead with bulkhead 舱壁与围壁	8	8,9	0.13	continuous 连续		5.0
43	bulkhead with bulkhead 舱壁与围壁	12	8	0.13	continuous 连续		5.0
44	bulkhead with bulkhead 舱壁与围壁	10~12	9	0.13	continuous 连续		5.0
45	bulkhead with bulkhead 舱壁与围壁	9	9	0.13	continuous 连续		5.0
46	wall with shell plate 围壁与外板	8	14	0.27	continuous 连续		5.0

NO	Structural Member to Link	plate (mm)	plate (mm)	Welding Parameter	Type of Welding	Leg of Fillet Weld (a)	
						single	double
序号	被 连 接 构 件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
47	wall with shell plate	9	14,14.5	0.27	continuous		5.0
	围壁与外板		15		连续		
48	wall with shell plate	10	14.5,15	0.27	continuous		5.0
	围壁与外板				连续		
49	web beams with upper deck	12	10,11	0.27	continuous		6.0
	强横梁与上甲板				连续		
50	web beams with upper deck	12	12	0.27	continuous		7.0
	强横梁与上甲板				连续		
51	girder with upper deck	10	10,11, 12,14	0.27	continuous		6.0
	纵桁与上甲板				连续		
52	web beams with face plate	12	14	0.13	continuous		5.0
	强横梁腹板与面板				连续		
53	girder web with face plate	10	12	0.13	continuous		5.0
	纵桁腹板与面板				连续		
54	web beams face plate with pillars	14	16	0.44	continuous		9.0
	强横梁面板与支柱				连续		
55	girder face plate with pillars	12	16	0.44	continuous		8.0
	纵桁面板与支柱				连续		
56	beams with upper deck	10	10,11	0.10	continuous		5.0
	横梁与上甲板				连续		
57	longitudinals with upper deck	10	10,12,14	0.10	continuous		5.0
	纵骨与上甲板				连续		
58	web beams with upper platform	10	9	0.27	continuous		5.0
	强横梁与机舱上平台				连续		
59	web beams with upper platform	10	10,14	0.27	continuous		6.0
	强横梁与机舱上平台				连续		
60	girder with upper platform	10	9	0.27	continuous		5.0
	纵桁与机舱上平台				连续		
61	girder with upper platform	10	14	0.44	continuous		6.0
	纵桁与机舱上平台				连续		
62	web beams & girder web with face plate	10	12	0.13	continuous		5.0
	强横梁、纵桁腹板与面板				连续		
63	beams with upper platform	10	9	0.10	continuous		5.0
	横梁与机舱上平台				连续		
64	beams with upper platform	10	10,14	0.10	continuous		5.0
	横梁与机舱上平台				连续		
65	web beams with lower platform	12	9	0.27	continuous		5.0
	强横梁与机舱下平台				连续		
66	web beams with lower platform	12	12	0.27	continuous		6.0
	强横梁与机舱下平台				连续		
67	girder with lower platform	10	9	0.27	continuous		5.0
	纵桁与机舱下平台				连续		
68	web beams with face plate	12	14	0.13	continuous		5.0
	强横梁腹板与面板				连续		

NO	Structural Member to Link	plate (mm)	plate (mm)	Welding Parameter	Type of Welding	Leg of Fillet Weld (a)	
						single	double
序号	被 连 接 构 件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
69	girder web with face plate 纵桁腹板与面板	10	12	0.13	continuous 连续		5.0
70	beams with oil tank top plate 横梁与油舱顶板	10	9	0.13	continuous 连续		5.0
71	longitudinals with oil tank top plate 纵骨与油舱顶板	10	8	0.13	continuous 连续		5.0
72	main frames with shell plate 主肋骨与外板	12	14.5,15	0.13	continuous 连续		5.0
73	twendeck frames with shell plate 甲板间肋骨与外板	12	14.5,15	0.13	continuous 连续		5.0
74	side longitudinals with shell plate 舷侧纵骨与外板	10,11	14,15	0.13	continuous 连续		5.0
75	web frames with shell plate 强肋骨与外板	14	14.5,15	0.21	continuous 连续		8.0
76	web frames with shell plate 强肋骨与外板	12	14.5,15	0.21	continuous 连续		7.0
77	web frames with shell plate 强肋骨与外板	10	14,15	0.21	continuous 连续		6.0
78	side stringer with shell plate 舷侧纵桁与外板	12	14.5,15	0.21	continuous 连续		7.0
79	side stringer with shell plate 舷侧纵桁与外板	10	14.5,15	0.21	continuous 连续		6.0
80	stiffener with bulkhead 扶强材与舱壁板	7	7	0.10	continuous 连续		5.0
81	stiffener with bulkhead 扶强材与舱壁板	7	8	0.10	continuous 连续		5.0
82	stiffener with bulkhead 扶强材与舱壁板	7	8,9	0.10	continuous 连续		5.0
83	stiffener with bulkhead 扶强材与舱壁板	10	7 , 8 , 9 10	0.10	continuous 连续		5.0
84	stiffener with bulkhead 扶强材与舱壁板	10	11,12	0.10	continuous 连续		5.0
85	stiffener with bulkhead 扶强材与舱壁板	11	9,11	0.10	continuous 连续		5.0
86	stiffener with Trans bulkhead 扶强材与横舱壁	12	11,12,13	0.13	continuous 连续		7.0
87	stiffener with Trans bulkhead 扶强材与横舱壁	10	8,9,10	0.13	continuous 连续		5.0
88	brackets 肘板		7		continuous 连续		4.0
89	brackets 肘板		8		continuous 连续		5.0
90	brackets 肘板		9		continuous 连续		5.0



NO	Structural Member to Link	plate (mm)	plate (mm)	Welding Parameter	Type of Welding	Leg of Fillet Weld (a)	
						single	double
序号	被连接构件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
91	brackets 肘板		10		continuous 连续		6.0
92	brackets 肘板		11		continuous 连续		7.0
93	brackets 肘板		12		continuous 连续		8.0
94	brackets 肘板		14		continuous 连续		9.0
三	<b>Fore. End Construction</b> <b>首部结构:</b>						
1	inner bottom with Trans. bulkhead 内底板与横舱壁	12	18.5	0.34	continuous 连续		7.0
2	inner bottom with center girder 内底板与中内龙骨	12	12	0.34	continuous 连续		7.0
3	inner bottom with side girder 内底板与旁龙骨	12	11	0.34	continuous 连续		6.0
4	inner bottom with floor 内底板与肋板	12	11	0.34	continuous 连续		6.0
5	center girder with Trans. bulkhead 中内龙骨与横舱壁	12	18.5	0.34	continuous 连续		7.0
6	floor with side girder 肋板与旁龙骨	11	11	0.34	continuous 连续		6.0
7	floor with shell plate 肋板与外板	11	18,15	0.34	continuous 连续		6.0
8	floor with center girder 肋板与中内龙骨	11	12	0.34	continuous 连续		6.0
9	Trans. bulkhead with upper deck 横舱壁与上甲板	10	10	0.44	continuous 连续		7.0
10	Trans. bulkhead with platform 横舱壁与平台	16,17	12	0.34	continuous 连续		7.0
11	Trans. bulkhead with platform 横舱壁与平台	12.5,15	12	0.34	continuous 连续		7.0
12	Trans. bulkhead with platform 横舱壁与平台	12.5	14	0.34	continuous 连续		7.0
13	Trans. bulkhead with platform 横舱壁与平台	11	9	0.34	continuous 连续		6.0
14	center girder with shell plate 中内龙骨与外板	12	20	0.44	continuous 连续		8.0

NO	Structural Member to Link	plate (mm)	plate (mm)	Welding Parameter	Type of Welding	Leg of Fillet Weld (a)	
						single	double
序号	被连接构件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
15	side girder with shell plate 旁龙骨与外板	11	15	0.34	continuous 连续		6.0
16	platform with shell plate 平台与外板	12	14,15,20	0.44	continuous 连续		8.0
17	platform with shell plate 平台与外板	9	16,20	0.44	continuous 连续		6.0
18	platform with shell plate 平台与外板	14	16,20	0.44	continuous 连续		9.0
19	upper deck with shell plate 上甲板与外板	10	13,20	0.44	continuous 连续		7.0
20	beams & longitudinals with upper deck 横梁、纵骨与上甲板	9	10	0.13	continuous 连续		5.0
21	girder & web Beam with upper deck 纵桁、强横梁与上甲板	10	10	0.34	continuous 连续		5.0
22	beams with platform 横梁与平台	10	12	0.13	continuous 连续		5.0
23	beams with platform 横梁与平台	10	14	0.13	continuous 连续		5.0
24	girder & web Beam with platform 纵桁、强横梁与平台	9	12	0.34	continuous 连续		5.0
25	girder & web Beam with platform 纵桁、强横梁与平台	9	14	0.34	continuous 连续		5.0
26	wall With Trans. bulkhead 围板与横舱壁	9	10~18.5	0.13	continuous 连续		5.0
27	wall With Trans. bulkhead 围板与横舱壁	14	10,11	0.13	continuous 连续		5.0
28	wall With Trans. bulkhead 围板与横舱壁	14	12.5	0.13	continuous 连续		5.0
29	upper deck with bulkhead 上甲板与舱壁板	10	9	0.34	continuous 连续		5.0
30	platform with bulkhead 平台与舱壁板	12	9	0.34	continuous 连续		5.0
31	stiffener with bulkhead 扶强材与舱壁板	10	10,11 12.5	0.13	continuous 连续		5.0
32	stiffener with Trans. bulkhead 扶强材与横舱壁	11	12.5~18	0.13	continuous 连续		5.0
33	vertical girder with Trans. bulkhead 垂直桁与横舱壁	9	10,11	0.34	continuous 连续		5.0
34	vertical girder with Trans. bulkhead 垂直桁与横舱壁	10	12.5~17	0.34	continuous 连续		5.0
35	vertical girder with bulkhead 垂直桁与舱壁	12	12,13	0.34	continuous 连续		5.0
36	stiffener with Trans. bulkhead 扶强材与横舱壁	10	9	0.13	continuous 连续		5.0

NO	Structural Member to Link	plate (mm)	plate (mm)	Welding Parameter	Type of Welding	Leg of Fillet Weld (a)	
						single	double
序号	被连接构件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
37	stiffener with Trans. bulkhead 扶强材与横舱壁	10	11	0.13	continuous 连续		5.0
38	frames with shell plate 肋骨与外板	11	13~20	0.13	continuous 连续		5.0
39	frames with shell plate 肋骨与外板	12	20	0.13	continuous 连续		5.0
40	side stringer with shell plate 舷侧纵桁与外板	10,12	13,16	0.13	continuous 连续		5.0
41	side stringer with face plate 舷侧纵桁与面板	10	12	0.13	continuous 连续		5.0
42	Chain-locker plate with upper deck 锚链舱壁与上甲板	14	10	0.44	continuous 连续		7.0
43	Chain-locker plate with 14400 platform 锚链舱壁与14400平台	14	14	0.44	continuous 连续		9.0
44	Chain-locker plate with 11900 platform 锚链舱壁与11900平台	14	14	0.44	continuous 连续		9.0
45	Chain-locker bilge well plate with platform 锚链舱污水井与平台	14	14	0.44	continuous 连续		9.0
46	Chain-locker bilge well clapboard With platform 锚链舱污水井隔板与平台	14	14	0.44	continuous 连续		9.0
47	stiffener with Chain-Locker plate 加强筋与锚链舱壁	11	14	0.13	continuous 连续		5.0
48	brackets 肘板	9,10			continuous 连续		6.0
49	brackets 肘板	11			continuous 连续		7.0
50	brackets 肘板	12			continuous 连续		8.0
51	center stiffener with stem plate 中纵筋与首柱板	12	20	0.44	continuous 连续		8.0
52	stem plate with upper deck 首柱板与上甲板	13	10	0.44	continuous 连续		7.0
53	stem plate with platforms 首柱板与平台	16,20	12	0.44	continuous 连续		8.0
54	stem plate with platforms 首柱板与平台	20	9	0.44	continuous 连续		6.0
四	After End Construction: 尾部结构:						
1	upper deck with shell plate 上甲板与外板	10	14	0.44	continuous 连续		7.0

NO	Structural Member to Link	plate (mm)	plate (mm)	Welding Parameter	Type of Welding	Leg of Fillet Weld (a)	
						single	double
序号	被连接构件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
2	upper deck with Transon 上甲板与尾封板	10	14	0.44	continuous 连续		7.0
3	upper deck with bulkhead 上甲板与舱壁	10	8	0.44	continuous 连续		5.0
4	upper deck with bulkhead 上甲板与舱壁	10	9	0.44	continuous 连续		6.0
5	12600 platform with shell plate 12600平台与外板	10	14	0.44	continuous 连续		7.0
6	12600 platform with Transon 12600平台与尾封板	10	14	0.44	continuous 连续		7.0
7	12600 platform with Trans. bulkhead 12600平台与横舱壁	10	9	0.44	continuous 连续		6.0
8	8000 platform with Trans. bulkhead 8000平台与横舱壁	12	12,16	0.44	continuous 连续		8.0
9	12600 platform with longi. bulkhead 12600平台与纵舱壁	10	9	0.44	continuous 连续		6.0
10	10100 platform with bulkhead 10100平台与舱壁	12	12	0.44	continuous 连续		8.0
11	12600 platform with pillars 12600平台与支柱	10	10,12	0.44	continuous 连续	7.0	
12	pillars with girder 支柱与桁材	12	12	0.44	continuous 连续	8.0	
13	girder with upper deck 桁材与上甲板	10	10	0.44	continuous 连续		7.0
14	girder with bulkheads 桁材与舱壁板	12	8,9	0.21	continuous 连续		5.0
15	girder web with Face plate 桁材腹板与面板	10,12	12,14	0.13	continuous 连续		5.0
16	beams with upper deck 横梁与上甲板	8	10,14	0.21	continuous 连续		5.0
17	side Stringer with shell plate 舷侧纵桁与外板	10	14	0.21	continuous 连续		5.0
18	Horizontal girder with bulkhead 水平桁与舱壁	10	8	0.21	continuous 连续		5.0
19	Horizontal girder with Transon 水平桁与尾封板	10	14	0.44	continuous 连续		7.0
20	web frames with shell plate 强肋骨与外板	15	14	0.44	continuous 连续		9.0
21	frames with shell plate 肋骨与外板	11,12	14	0.21	continuous 连续		5.0
22	stiffener with Transon 扶强材与尾封板	10	14	0.21	continuous 连续		5.0
23	stiffener with Transon 扶强材与尾封板	12	14	0.21	continuous 连续		5.0

NO	Structural Member to Link	plate (mm)	plate (mm)	Welding Parameter	Type of Welding	Leg of Fillet Weld (a)	
						single	double
序号	被连接构件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
24	stiffener with Trans. bulkhead	10	12,16,20,	0.21	continuous		5.0
	扶强材与横舱壁		30		连续		
25	stiffener with Trans. bulkhead	9	8,9	0.21	continuous		5.0
	扶强材与横舱壁				连续		
26	stiffener with longi. bulkhead	9	8,12	0.21	continuous		5.0
	扶强材与纵舱壁				连续		
27	stiffener with bulkheads	10	9	0.21	continuous		5.0
	加强筋与舱壁板				连续		
28	floor with platform	12	12	0.21	continuous		5.0
	肋板与平台				连续		
29	floor with platform	20	20	0.21	continuous		7.0
	肋板与平台				连续		
30	floor with platform	16	20	0.21	continuous		6.0
	肋板与平台				连续		
31	floor with platform	12	10	0.21	continuous		5.0
	肋板与平台				连续		
32	floor with shell plate	12	14,16,20	0.34	continuous		6.0
	肋板与外板				连续		
33	floor with shell plate	16,20	16	0.34	continuous		8.0
	肋板与外板				连续		
34	side girder with platform	12	10	0.34	continuous		5.0
	旁桁材与平台				连续		
35	side girder with platform	12	12	0.34	continuous		6.0
	旁桁材与平台				连续		
36	side girder with Trans. bulkhead	12	12	0.34	continuous		6.0
	旁桁材与横舱壁				连续		
37	side girder with floor	12	12	0.34	continuous		6.0
	旁桁材与肋板				连续		
38	walls with Trans. bulkhead	10	12	0.34	continuous		5.0
	围壁板与横舱壁				连续		
39	stiffener with floor	12	12,16,20	0.21	continuous		5.0
	加强筋与肋板				连续		
40	stiffener with floor	9	12	0.21	continuous		5.0
	加强筋与肋板				连续		
41	stiffener with floor	16,18	18	0.21	continuous		7.0
	加强筋与肋板				连续		
42	Rudder horn plate with ship shell	58	20		penetration		
	挂舵臂板与船体外板				深熔焊		
43	Rudder horn with ship shell	30	16		penetration		
	挂舵臂与船体外板				深熔焊		
44	Rudder horn plate with partition	58	30		penetration		
	挂舵臂板与隔板				深熔焊		
45	Rudder bearing with partition		30		penetration		
	舵承与隔板				深熔焊		

NO	Structural Member to Link	plate (mm)	plate (mm)	Welding Parameter	Type of Welding	Leg of Fillet Weld (a)	
						single	double
序号	被 连 接 构 件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
46	Rudder horn plate with plate 挂舵臂板与板	30	30	0.44	continuous 连续		18.5
47	Horizontal Stock with Perpendicular Stock 水平隔板与垂直隔板	30	30	0.44	continuous 连续		18.5
48	Rudder horn plate with 12600 platform 挂舵臂板与12600平台	30	20	0.44	continuous 连续		12.5
49	Rudder horn plate with floor plate 挂舵臂板与肋板	30	20	0.44	continuous 连续		12.5
50	Rudder horn plate with floor plate 挂舵臂板与肋板	30	16	0.44	continuous 连续		10.0
51	skeg plate with shell plate 假舵与外板	14	20	0.44	continuous 连续		9.0
52	skeg plate with clapboard 假舵与隔板	14	12	0.34	continuous 连续		6.0
53	clapboard with shell plate 隔板与外板	12	20	0.34	continuous 连续		6.0
54	horizontal clapboard with shell plate 水平隔板与外板	21	20	0.34	continuous 连续		10.0
55	horizontal clapboard with shell plate 水平隔板与外板	21	42	0.34	continuous 连续		10.0
56	horizontal clapboard with bulkhead plate 水平隔板与舱壁板	21	20	0.34	continuous 连续		10.0
57	brackets 肘板		9		continuous 连续		5.0
58	brackets 肘板		10		continuous 连续		6.0
59	brackets 肘板		11		continuous 连续		7.0
六	<b>Forecastle Construction :</b> <b>首楼结构:</b>						
1	Forecastle deck with shell plate 首楼甲板与外板	10,16	11	0.21	continuous 连续		6.0
2	Forecastle deck with bulkhead 首楼甲板与舱壁	10	7	0.21	continuous 连续		5.0
3	Forecastle deck with Inner wall 首楼甲板与内围壁	10,12 15	7	0.13	continuous 连续		5.0
4	Chain-locker plate With Forecastle deck 锚链舱壁与首楼甲板	10	15	0.44	continuous 连续		6.0
5	lough. with Forecastle deck 纵骨与首楼甲板	10	10,12 15	0.13	intermittent 间断		6.0 6-75Z200
6	girder & web Beam with Forecastle deck 纵桁、强横梁与首楼甲板	10	10,12 15	0.21	continuous 连续		5.0

NO	Structural Member to Link	plate (mm)	plate (mm)	Welding Parameter	Type of Welding	Leg of Fillet Weld (a)	
						single	double
序号	被连接构件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
7	stiffener with Trans. bulkhead	9	7	0.13	intermittent		5.0
	扶强材与横舱壁				间断		5-75Z200
8	stiffener with Inner wall	7	7	0.13	intermittent		5.0
	扶强材与内围壁				间断		5-75Z200
9	stiffener with Inner wall	10	10	0.13	intermittent		6.0
	扶强材与内围壁				间断		6-75Z200
10	frames with shell plate	11	11,20	0.13	continuous		5.0
	肋骨与外板				连续		
11	web frames with shell plate	10	11,20	0.13	continuous		5.0
	强肋骨与外板				连续		
12	Horizontal girder with shell plate	10	11,16 20	0.21	continuous		5.0
	水平桁与外板				连续		
13	Horizontal girder with Face plate	10	12	0.21	continuous		5.0
	水平桁与面板				连续		
14	upper deck With pillars	9	12	0.44	continuous		6.0
	上甲板与支柱				连续		
15	pillars With web Beam & girder	12	12	0.44	continuous	8.0	
	支柱与纵桁,强横梁				连续		
16	brackets	7			continuous		4.0
	肘板				连续		
17	brackets	8			continuous		5.0
	肘板				连续		
18	brackets	9			continuous		5.0
	肘板				连续		
19	brackets	10			continuous		6.0
	肘板				连续		
七	<b>Mast house construction</b>						
	<b>桅屋结构:</b>						
1	upper deck with crane post	20	32		penetration		
	上甲板与起重柱机座				深熔焊		
2	upper deck plate with Outside walls	11,20	8	0.34	continuous		5.0
	上甲板与外围壁				连续		
3	upper deck plate with Outside walls	20	10	0.34	continuous		5.0
	上甲板与外围壁				连续		
4	top plate with crane post	10	32		penetration		
	顶板与起重柱				深熔焊		
5	Outside walls with crane post	10	32		penetration		
	外围壁与起重柱				深熔焊		
6	Outside walls with Outside walls	8	8	0.34	continuous		5.0
	外围壁与外围壁				连续		
7	top plate with Outside walls	8	8	0.34	continuous		5.0
	顶板与外围壁				连续		

NO	Structural Member to Link	plate (mm)	plate (mm)	Welding Parameter	Type of Welding	Leg of Fillet Weld (a)	
						single	double
序号	被连接构件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
8	top plate with Outside walls 顶板与外围壁	10	10	0.34	continuous 连续		5.0
9	stiffener with Outside walls 扶强材与外围壁	7 9	8,10	0.21	intermittent 间断		6.0 6-75Z200
10	longitudinals with Crown 纵骨与顶板	7	8,10	0.21	intermittent 间断		5.0 5-75Z200
11	brackets 肘板	7			continuous 连续		4.0
八	Superstructure and deckhouse: 上层建筑和甲板室:						
1	upper deck plate with Outside walls 上甲板与外围壁	10,12, 14	9	0.34	continuous 连续		5.0
2	upper deck plate with Outside walls 上甲板与外围壁	11,14	10	0.34	continuous 连续		6.0
3	A deck plate with Outside walls A 甲板与外围壁	8	9,10	0.21	continuous 连续		5.0
4	B deck plate with Outside walls B 甲板与外围壁	8	8	0.21	continuous 连续		5.0
5	C deck plate with Outside walls C 甲板与外围壁	7	8	0.21	continuous 连续		5.0
6	Bridge deck plate with Outside walls 驾驶甲板与外围壁	7	7	0.21	continuous 连续		5.0
7	Compass deck plate with Outside walls 罗经 甲板与外围壁	7 10	7 8	0.21	continuous 连续		5.0
8	upper deck plate with Inside walls 上甲板与内围壁	10,11, 12,14	7	0.34	continuous 连续		4.0
9	Inside walls with Outside walls on upper deck 上甲板内围壁与外围壁	7	9,10	0.34	continuous 连续		4.0
10	Inside walls with Inside walls on upper deck 上甲板内围壁与内围壁	7	7	0.34	continuous 连续		4.0
11	Other deck plate with Inside walls 其余甲板与内围壁	8	6	0.21	continuous 连续		4.0
12	Other deck plate with Inside walls 其余甲板与内围壁	7	6	0.21	continuous 连续		4.0
13	Inside walls with Outside walls on Other deck 其余甲板内围壁与外围壁	6	7,8	0.21	continuous 连续		4.0
14	Inside walls with Inside walls on Other deck 其余甲板内围壁与内围壁	6	6	0.21	continuous 连续		4.0
15	girders with deck plate 桁材与甲板	8 10	7		intermittent 间断		5.0 5-75Z200
16	girders with deck plate 桁材与甲板	8	8		intermittent 间断		5.0 5-75Z200



NO	Structural Member to Link	plate (mm)	plate (mm)	Welding Parameter	Type of Welding	Leg of Fillet Weld (a)	
						single	double
序号	被 连 接 构 件	板厚 (mm)	板厚 (mm)	焊接 系数	焊接 形式	焊脚高度	
						单面	双面
17	plate with beams on A & B deck	8	8		intermittent		5.0
	A、B甲板与横梁				间断		5-75Z200
18	plate with beams on C~Compass deck	7	7		intermittent		5.0
	C~罗经甲板与横梁		10		间断		5-75Z200
19	stiffener with Outside walls	10	8,9		intermittent		6.0
	扶强材与外围壁(潮湿区域除外)	11	10		间断		6-75Z200
20	stiffener with Outside walls	7	7		intermittent		5.0
	扶强材与外围壁(潮湿区域除外)		8		间断		5-75Z200
21	stiffener with Inside walls	6	6,7		intermittent		5.0
	扶强材与内围壁(潮湿区域除外)				间断		5-75Z200
22	stiffener with Outside walls	10	8,9	0.10	continuous		4.0
	扶强材与外围壁(潮湿区域)				连续		
23	stiffener with Outside walls	7	7	0.10	continuous		4.0
	扶强材与外围壁(潮湿区域)				连续		
24	stiffener with Inside walls	6	6,7	0.10	continuous		4.0
	扶强材与内围壁(潮湿区域)				连续		
25	Brim with deck plate	8	7		continuous		5.0
	檐板与甲板				连续		
26	Brim with deck plate	8	8		continuous		5.0
	檐板与甲板				连续		
27	brackets	7			continuous		4.0
	肘板				连续		
28	brackets	8			continuous		5.0
	肘板				连续		
29	brackets	10			continuous		6.0
	肘板				连续		